

PRODUCT OF THE MONTH MAY

35% discount

ON OUR MILL-THREAD SOLID CARBIDE

Type MTQ

Promotional Code: **PDM26-05**



Product of the Month for May:
Solid Carbide Thread Milling Cutter Type MTQ

Advantages:

high rigidity & low-vibration machining, deep threads in a single pass, low cutting pressure thanks to shortened cutting edge, thread lengths up to 3xD

Applications:

Ideal for producing threads in medium and deep bores.

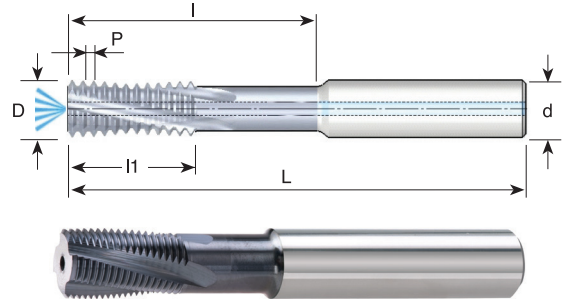
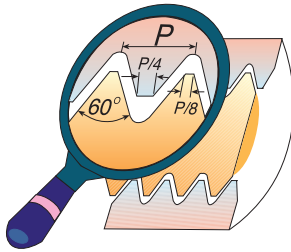
Carbide Grade MT7:

Ultra-fine grain grade with TiAlN multi-layer coating (ISO K10–K20) – suitable for medium to high cutting speeds and usable in all materials.

Please specify in your order the article numbers of the chosen MTQ Mill-Thread Solid Carbide and the promotional code: PDM26-05.

ISO With relieved neck and internal coolant bore

Tools for Internal Thread



Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch mm	M fine	Ordering Code	d	D	No. of Flutes	l1	l	L
1.0	$\varnothing \geq 12$	MTQ 1010 D32 1.0 ISO	10	10.0	4	18.0	32.0	73
1.0	$\varnothing \geq 14$	MTQ 1212 D38 1.0 ISO	12	12.0	4	21.0	38.0	84
1.0	$\varnothing \geq 18$	MTQ 1616 F45 1.0 ISO	16	16.0	6	26.0	45.0	105
1.5	$\varnothing \geq 13$	MTQ 1010 D30 1.5 ISO	10	10.0	4	18.0	30.0	73
1.5	$\varnothing \geq 15$	MTQ 1212 D34 1.5 ISO	12	12.0	4	19.5	34.5	84
1.5	$\varnothing \geq 19$	MTQ 1616 F43 1.5 ISO	16	16.0	6	25.5	43.5	105
1.5	$\varnothing \geq 23$	MTQ 2020 F60 1.5 ISO	20	20.0	6	36.0	60.0	105
2.0	$\varnothing \geq 16$	MTQ 1212 D42 2.0 ISO	12	12.0	4	24.0	42.0	84
2.0	$\varnothing \geq 20$	MTQ 1616 E45 2.0 ISO	16	16.0	5	26.0	45.0	105
2.0	$\varnothing \geq 24$	MTQ 2020 F56 2.0 ISO	20	20.0	6	34.0	56.0	105
3.0	$\varnothing \geq 22$	MTQ 1616 D45 3.0 ISO	16	16.0	4	30.0	45.0	105
3.0	$\varnothing \geq 26$	MTQ 2020 E54 3.0 ISO	20	20.0	5	33.0	54.0	105
3.5	$\varnothing \geq 26$	MTQ 2020 D45 3.5 ISO	20	20.0	4	28.0	45.5	105
4.0	$\varnothing \geq 31$	MTQ 2525 D64 4.0 ISO	25	25.0	4	40.0	64.0	160

Order example: MTQ 1010 D30 1.5 ISO MT7

● First choice

○ Alternative



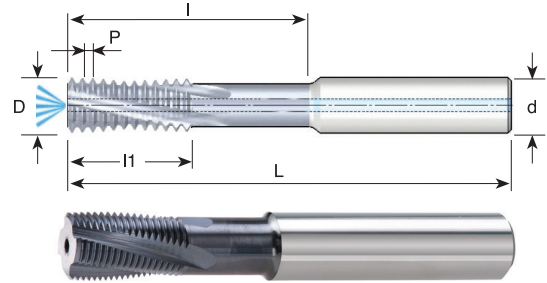
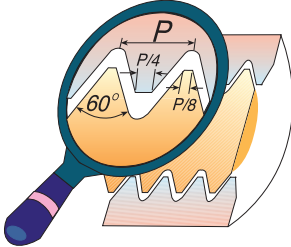
TOOL FINDER & CUTTING DATA

For small thread mills see pages B09-3, 4, 11, 15, 17 and B11-3, 6



UN With relieved neck and internal coolant bore

Tools for Internal Thread



Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	Thread size	Ordering Code	d	D	No. of Flutes	l1	l	L
20	$\varnothing \geq 12$	MTQ 1010 D30 20 UN	10	10.0	4	17.8	30.5	73
20	$\varnothing \geq 14$	MTQ 1212 E35 20 UN	12	12.0	5	20.3	35.6	84
20	$\varnothing \geq 18$	MTQ 1616 F43 20 UN	16	16.0	6	25.4	43.2	105
18	$\varnothing \geq 15$	MTQ 1212 D35 18 UN	12	12.0	4	19.7	35.3	84
16	$\varnothing \geq 15$	MTQ 1212 D35 16 UN	12	12.0	4	20.7	35.0	84
16	$\varnothing \geq 19$	MTQ 1616 E42 16 UN	16	16.0	5	25.4	42.9	105
16	$\varnothing \geq 23$	MTQ 2020 F58 16 UN	20	20.0	6	36.5	58.8	105
14	$\varnothing \geq 20$	MTQ 1616 E45 14 UN	16	16.0	5	25.4	45.3	105
12	$\varnothing \geq 16$	MTQ 1212 D42 12 UN	12	12.0	4	25.4	42.3	84
12	$\varnothing \geq 24$	MTQ 2020 E55 12 UN	20	20.0	5	33.9	55.1	105

Order example: MTQ 1212 D35 16 UN MT7

● First choice ○ Alternative



TOOL FINDER & CUTTING DATA



MTQ type

Thread mills with relieved neck and internal coolant for milling medium and large threads on relatively deep work pieces.

- To produce medium and large threads on relatively deep work pieces.
- To use overhang according to the application.
- To perform deep threads at the bottom of the application.

Advantages

- Provides high rigidity and stability (anti-vibration).
- Accomplishes deep threads in one pass.
- Relatively low cutting forces due to short cutting length.
- Threads length up to 3D.

Cutting Data

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed m/min	Feed mm/tooth Cutting Diameter=D					
			Ø10	Ø12	Ø14	Ø16	Ø20	Ø25
P	Low and Medium Carbon Steels < 0.55%C	100 - 250	0.06	0.07	0.07	0.08	0.10	0.12
	High Carbon Steels ≥ 0.55%C	110 - 180	0.05	0.05	0.06	0.07	0.09	0.10
	Alloy Steels, Treated Steels	90 - 160	0.03	0.04	0.04	0.05	0.06	0.07
M	Stainless Steels - Free Cutting	60 - 160	0.04	0.04	0.05	0.06	0.06	0.08
	Stainless Steels - Austenitic	60 - 120	0.04	0.04	0.04	0.05	0.06	0.07
	Cast Steels	130 - 170	0.03	0.04	0.04	0.05	0.06	0.07
K	Cast Iron	70 - 150	0.06	0.07	0.07	0.08	0.10	0.12
N	Aluminum ≤ 12%Si, Copper	150 - 350	0.06	0.07	0.07	0.08	0.10	0.12
	Aluminum > 12% Si	100 - 250	0.03	0.04	0.04	0.05	0.06	0.07
	Synthetics, Duroplastics, Thermoplastics	100 - 400	0.08	0.09	0.10	0.11	0.13	0.15
S	Nickel Alloys, Titanium Alloys	20 - 80	0.02	0.02	0.02	0.03	0.03	0.03

